Work Order ID June-12-13 9:26:39 AM	103082		*103	3082*			,			Page 1
Item ID: 646.3912 Revision ID:	2		Accept	*N900	040	100)* s	etup Sta	I	S1*
Item Name: Shim								Sto	$^{\rm p}$ * N	S2*
Start Date: 6/11/13	Start Qty: 20.			Cust Item 1	D:					
Required Date: 6/11/13	Req'd Qty: 20.	⁰⁰ *20	*	Customer:						
Reference:		A1						tun Sta	mt	
Approvals: Process	s Plan:	Date: 13-0/2-	Tooling:	D:	ate:	<u> </u>	К		1/1	R1*
QC:		Date:	SPC (Y/N):	D	ate:			Sto	^p *N	R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
646.3900	N/C									
110			0.00							
110 Waterjet	Memo		0.00	,			70			Jm13:08-1
FLOW CNC Waterjet	Dwg Re	s per Dwg ev: $\sqrt{/C}$	·							
Blue Spring Steel	•	rr if necessary								
120	QC2- Inspect parts of	off machine FAI/FAIB	0.00							
120 QC	Memo		0.00				70	&		JM3-08.1

Memo

Quality Control

DQA:			. Date:			-							***	
QA Closed:			Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UI		Iorle Ordon un	ndata anku [_	AEROSPACE
QA CIOSEU.			Date.							V	ork Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS		
	•			-		Rework			Skid-tube	Crosstube		Water Jet		Engineering
Part N	No.					Scrap		1	Machining	Small Fab	Pro	d. Eng. Coor.		Quality
						Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging		Other
NCR N	No.			•		Suspected Unapproved			Large Fab	Composite		Supplier		
Dood					Doss	rintian of work arder undete		nitial	Λ α φ	ion	Cian 0			
Root		Date	Ston	Otu	Desc	ription of work order update or non-conformance		Initial	Act		Sign &	Verification		OCInsportor
Cause		Date	Step	Qty		or non-comormance	Cil	ief Eng	Descr	iption	Date	verification	+	QC Inspector
Design Doc/Data	\vdash													
Equip/Tooling	\vdash													
Handling/Pre														
Material	П													
Operator														
Offset/Setup														
Process														
Supplier														
Training														
Transport														
Unapproved											<u> </u>			
							FAI	ULT CAT	EGORY					
Landi					_	General	_			_	-n	_	_	
	lacksquare	Bending				Bend		i '	rogram	<u> </u>	Outside Dim	-	_	essure/Forced
	Ш	Centre No	ot Concer	ntric	-	BOM/Route		Grain		<u> </u>	Over/Under	<u> -</u>		et-up
	Ш	Cracks				Broken/Damage/Defect		Hardwa			Part Incorred	⊢	_	emperature/Cure
	\vdash	Crimp/Kir	nk/Ripple	/Wave		Burrs	_	1	on Incomplete/Un	· —	Part Lost/Mi	ssing		eld
	\vdash	Cuffs				Contamination	_	1	ions Incomplete/U	Jnclear	Part Moved	L	\w	rong Stock Pulled
	\vdash	Crushing			-	Countersink	_	_	ned/off center	_	Positioned V		- -	
·	-	Heat Trea		T b	<u> </u>	Cut Too Short	\vdash	Mislabe		L	Power Loss/	Surge	10	ther
	-	Inspection		rube	<u> </u>	Drawing	_	Misread	I					
	\vdash	Marks/Ch			<u> </u>	Drill Holes	-	Off-set	Salibanai a					
	\vdash	Turning S		_	-	Finish Fit (Function	\vdash	1	Calibration					
	L	Wave/Tw	rist in Tub	e		Fit/Function	L	Out of S	equence					

Work Ord June-12-13 9:2		03082		*1030	182*					Page 2
Item ID: Revision ID: Item Name:	646.3912 Shim			Accept	*N <u>9</u> 00	<u>040100</u>)* s	Setup Start	IVI.	31* 32*
Start Date: Required Date: Reference:	6/11/13 : 6/11/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item II Customer:	D:				
Approvals:	Process P QC:	'lan:	Date:	Tooling: SPC (Y/N):	Da		F	Run Start Stop	"INF	२1* २2*
Sequence ID/ Work Center I 130 *130* QC Quality Control	D	Operation Description QC8- Inspect parts - secon	d check	Set Up/ Run Hours 0.00 Smf 0.00 13 8 14	Tool ID	Tool # Plan Code	Accept Qty	Reject Qty	•	Insp. Stamp
*140 *140* Outsource3 Outsource process	- Cad plate	Outsource process-Cadplate Memo Issue P/O:	te per QSI017 4.1.9.1	0.00			_(~	Z_13/4	08/19	<u> </u>
150 *150*		Receive & Inspect for Dan	nage & Mat'l Certs	0.00				1931	<u>6/11</u>	(20)

0.00

Memo

Packaging

Packaging

DQA:			Date:			. WORK ORDER NON	~		284881CE / 11	IDDATE			
QA Closed:			Date:			WORK ORDER NON-	-((JNFOI	RIVIANCE / U		ork Order up	odate only	AERŌSPĀCĒ
						DISPOSITION				AGAINST DI	PARTMENT	/PROCESS	
Work Orde	er: .					Rework			Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	No.					Scrap		!	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	٠٠.	-				Use-as-is			noforming	Finishing	-	re/Packaging	Other
NCR I	۷o. ِ		-···			Suspected Unapproved			Large Fab	Composite]	Supplier	
Root					Desc	ription of work order update		nitial	۸۵	tion	Sign &	,	
Cause		Date	Step	Qty	Desc	or non-conformance		ief Eng		cription	Date	Verification	QC Inspector
Design	П	Dute	Step	Qty	*****	or non comormance		ner, eng	<i>Desc</i>	ription	Date	vermeation	QC IIISPECTOI
Doc/Data	H												
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Operator													
Offset/Setup													
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Supplier													
Training	Ш												
Transport	Ш												
Unapproved											-		<u> </u>
							FAI	ULT CAT	EGORY				<u></u>
Landi		1				General		1			٦		7
	-	Bending			<u> </u>	Bend			rogram		Outside Dim	·	Pressure/Forced
	Н	Centre No	ot Concen	itric	<u> </u>	BOM/Route		Grain			Over/Under		Set-up
	\vdash	Cracks	-1. /D:l-	/s.a		Broken/Damage/Defect		Hardwa		La concedition of	Part Incorred	 	Temperature/Cure
		Crimp/Kir	тк/кірріе,	/wave	-	Burrs		i '	on Incomplete/U		Part Lost/Mi	ssing	Weld
	├ ──┤	Cuffs Crushing				Contamination Countersink		4	ions Incomplete/ ned/off center	Unclear	Part Moved Positioned V	L.	Wrong Stock Pulled
	-	Heat Trea	·+		-	Cut Too Short		Mislabe		-	Power Loss/		Other
	\vdash	Inspection		Tubo	-	Drawing	-	Misread			Trower ross/	ourge	Joulei
	-	Marks/Ch		Tube	-	Drill Holes		Off-set	ı				
	$\vdash \vdash$	Turning S			-	Finish		ł	Calibration				
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H-/EORMS/Ou		l				in the state of th		100001	-cquerice				· · · · · · · · · · · · · · · · · · ·

Work Ord June-12-13 9:2		3082		*103	N82*				1		Page 3
Item ID: Revision ID: Item Name: Start Date: Required Date Reference:	646.3912 Shim 6/11/13 : 6/11/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*	Accept	*N90004 Cust Item ID: Customer:	4010	ገ በ*	Setup	Start Stop	171.	S1* S2*
Approvals:		an:	Date:	Tooling:	Date:			Run	Start Stop	"	R1* R2*
Sequence ID/ Work Center I 160 *160* QC QC Quality Control	D	Operation Description QC5- Inspect part comple Memo	eteness to step on W/O	Set Up/ Run Hoursas 0.00 27 9.89 0.00 3		Cool # Pla Coo		ot Re Qt		Reject Number	Insp. Stamp
170 *170* Packaging Packaging		Identify as per dwg & Sto Memo ***IDENTIF REV***	ock Location \$153	0.00 0.00 -120 BY STAMPING TH	E P# AND		20	L _		/	δρ 3-9-
180 *180* QC Quality Control		QC21- Final Inspection -	Work Order Release	0.00					/5	3/9/	16 A
										. 10	

of moans

DQA:			Date:										***	DART	
QA Closed:			Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UF		ork Order up	odate only		AEROSPACE	
Mark Ord						DISPOSITION					EPARTMENT		 .		
Work Orde	er:				—	Davis de l'	ı		artin In E	C	٦		一 .		
Part i	No					Rework Scrap Use-as-is			Skid-tube Machining	Crosstube Small Fab		Water Jet d. Eng. Coor.]	Oth -	
NCR I	۷o					Suspected Unapproved		mern	noforming Large Fab	Finishing Composite	Rec/stor	re/Packaging Supplier		Other	
Root	1				Desci	ription of work order update		nitial	Acti	on	Sign &		T		١
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	ı	QC Inspector	
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Doc/Data															
Equip/Tooling															
Handling/Pre								ę.							
Material								ಎ	·						
Operator					•			· ξ							
Offset/Setup															
Process															
Supplier															
Training															
Transport															
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							FAI	ULT CAT	EGORY						•
Landi	ng Ge	ar				General		_							•
	Шв	ending				Bend		Folio/P	rogram		Outside Dim	ensions	Pre	essure/Forced	
	c	entre No	ot Concen	itric		BOM/Route		Grain			Over/Under	tolerance	Se	t-up	
	c	racks				Broken/Damage/Defect		Hardwa	re		Part Incorred	ct [Ter	mperature/Cure	
:	c	rimp/Kir	ık/Ripple/	/Wave		Burrs		Inspecti	on Incomplete/Un	qualified	Part Lost/Mi	ssing	We	eld	
	c	uffs				Contamination		Instruct	ions Incomplete/U	nclear	Part Moved		Wr	ong Stock Pulled	
	. c	rushing				Countersink		Misalig	ned/off center		Positioned W	/rong			
	Пн	eat Trea	t			Cut Too Short		Mislabe	led		Power Loss/	Surge	Otl	ner	
	[]Ir	rspection	n Strip in	Tube		Drawing		Misread	I	<u></u>					•
	\square	1arks/Ch	atter			Drill Holes		Off-set							•
	Пт	urning S	equence			Finish		Out of (Calibration			,			•
	\square_{v}	/ave/Tw	ist in Tub	e		Fit/Function		Out of S	eauence						•

Picklist Print

June-12-13 9:26:39 AM

Work Order ID:

103082

Parent Item:

646.3912

Parent Item Name:

Shim

Start Date: 6/11/13

Required Date: 6/11/13

Page 1

Start Qty: 20.00

Required Qty: 20.00

IPP REV:A 12.10.23 NEW ISSUE DD VERF:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MC1095S.020 C1095 Blue Tempered Sp	ring Steel Sheet .020	Purchased	No			110	sf	6.9000	0.02	_0.4 21052 6		フ	m13084
				Location		Loc Oty	Lo	c Code					
				MAT022		6.9							
				12353	37	6.9			-				
									126	423			

126423

166962

DQA:		_ Date:											``AA®T
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDA		ork Ordor un	ndata anly - [_	AEROSPACE
QA Closed.		Date.						<u>-</u>	VV	ork Order up	date only		
Work Orde	er:				DISPOSITION			A	GAINST DE	PARTMENT	/PROCESS		
					Rework			Skid-tube Cro	osstube		Water Jet		Engineering
Part N	lo.				Scrap			Machining Sm	nall Fab	Pro	d. Eng. Coor.		Quality
			•		Use-as-is		Thern	noforming Fi	inishing	Rec/Stor	re/Packaging		Other
NCR N	lo				Suspected Unapproved			Large Fab Con	nposite 🔃		Supplier		
			1				L			<u> </u>			
Root				Desci	ription of work order update		Initial	Action		Sign &		ı	
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description	1	Date	Verification	1	QC Inspector
Design					•								
Doc/Data													
Equip/Tooling													
Handling/Pre	_											-	
Material								•					
Operator													
Offset/Setup													
Process													
Supplier													
Training													
Transport													
Unapproved			l										
						FAL	ULT CAT	EGORY					
Landir	ng Gear			_	General		1			I	Г	_	
	Bending			<u> </u>	Bend	-	1	rogram	<u> </u>	Outside Dim	+	\neg	Pressure/Forced
		ot Concer	ntric	<u> </u>	BOM/Route		Grain		ļ	Over/Under		$\overline{}$	Set-up
	Cracks				Broken/Damage/Defect		Hardwa			Part Incorred		\dashv	Temperature/Cure
		nk/Ripple	:/Wave	<u> </u>	Burrs		1 '	on Incomplete/Unqualif	_	Part Lost/Mi	ssing	\dashv	Weld
	Cuffs			<u> </u>	Contamination	_	ł	ions Incomplete/Unclear	r	Part Moved	Ĺ		Wrong Stock Pulled
	Crushing			<u> </u>	Countersink	_	1	ned/off center		Positioned W			
	Heat Tre			\vdash	Cut Too Short		Mislabe			Power Loss/S	Surge [Other
		n Strip in	Tube	<u> </u>	Drawing	_	Misread	1					
	Marks/Cl			<u> </u>	Drill Holes		Off-set						
		Sequence		<u> </u>	Finish		4	Calibration					
	Wave/Tv	vist in Tub	oe		Fit/Function		Out of S	equence					

DART AEROSPACE LTD	Work Order:	103082
Description: Shirm	Part Number:	646.3912
Inspection Dwg: 646-3900 Rev:		Page 1 of 1

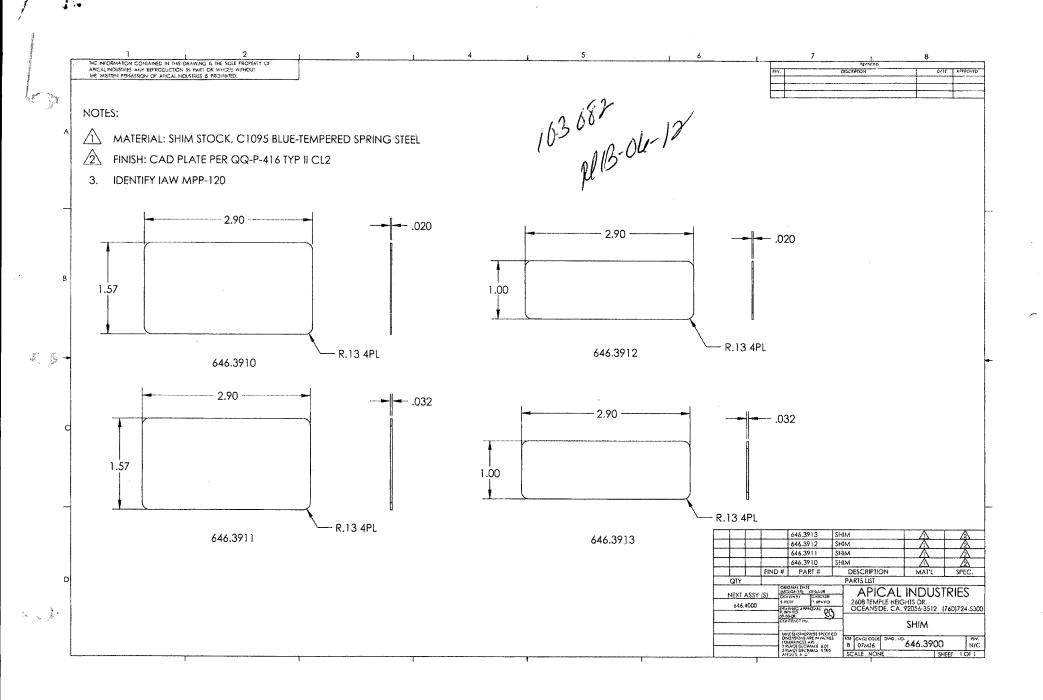
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
-000	4,000	T.006"	_		U	JLMO,
2.90"	H=0.010"	2.898"	-		V	
0.000	f10,0,00	0.020,	_		V	
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Measured by:	IM	Audited by:	Sho	Preliminary Approval:	:
Date:	17-08-14	Date:	13 A 14	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

\$ 10.04.15



CERTIFICATE OF CONFORMANCE

CADORATH PLATING CO. LTD. 2150 LOGAN AVENUE WINNIPEG, MANITOBA R2J-0J1

DATE:

Sep-10-2013

CONSIGNED TO: Dart Aerospace Ltd.

1270 Aberdeen St.

Hawksbury, ON K6A 1K7

W/O #:

127629

INVOICE #:

QTY

67490

20

CONTRACT OR

PURCHASE ORDER #

PO20975

DESCRIPTION:

SHIM

P/N # 646.3912

S/N # 103082

CADMIUM PLATING IAW AMS-QQ-P-416C TYPE 2 YELLOW CLASS 2. BAKE HEAT CHART # 13-787.

CERTIFICATE: I certify that the items indicated here on have been inspected and tested and conform to all specifications and requirements detailed on the contract or purchase order.

Approved Inspector: